

Work Order ID 105612

Thursday, August 08, 2013 2:34:56 PM

105612

Page 1

Item ID: D3492-5

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Plug

Start Date: 8/8/2013 Start Qty: 80.00

80

Cust Item ID:

Required Date: 8/22/2013 Req'd Qty: 80.00

80

Customer:

Reference:

Approvals: Process Plan: MCT

Date: 13-08-08

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3492

D

100

0.00

100

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-Turn as per Folio FA634 & Dwg D3492

Dwg Rev: D

Folio Rev: _____

DAS
44
9-89

13/08/09

80

Ø

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

DAS
44
9-89

13/08/09

80

Ø

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

REP 13-8-10

80

Ø

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Page 2

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Cust Item ID:

Required Date: 8/22/2013 Req'd Qty: 80.00

80

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

80

13-08-14

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

160

Powdercoat

Memo

(Flat End Only)

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

10:00
320°F
10:30

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

80x8 m/f 13/08/15

804 & Ill us 100/c-

m126125

Work Order ID 105612

Thursday, August 08, 2013 2:34:56 PM

105612

Page 3

Item ID: D3492-5

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Plug

Start Date: 8/8/2013 Start Qty: 80.00

80

Cust Item ID:

Required Date: 8/22/2013 Req'd Qty: 80.00

80

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

180

Identify as per dwg & Stock Location: FP

0.00

180

Packaging

Memo

0.00

Packaging

80X 11.12.13-08-16

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

13/8/20 13

MR

13-8-16

Picklist Print

Thursday, August 08, 2013 2:35:00 PM

Page 1

Work Order ID: 105612

105612

Parent Item: D3492-5

D3492-5

Parent Item Name: Plug

Start Date: 8/8/2013

Required Date: 8/22/2013

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP Rev:A 11.04.19 per dwg revC DD ver:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.375		Purchased	No			100	f	26.2780	0.06	5.052632			

M6061T6R0.375

6061-T6 Round Bar .375"

*.500"
 After Batched only
 Just 13-08-09*

Location

MAT012

Loc Qty

26.278

112567

8.54

120708

5.924

123483

11.814

Loc Code

*6061-T6
 .500"*

125552

*5.06' DAS
 44
 9-23 13/08/09.*

Could not pull mat 16

D3492-XX PLUG
(SEE TABLE)

NAS1611 O-RING
(SEE TABLE)

D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
		1					NAS1611-005	O-RING
			1				NAS1611-007	O-RING
1							NAS1611-010	O-RING
						1	NAS1611-012	O-RING
	1						NAS1611-013	O-RING
					1		NAS1611-015	O-RING
				1			NAS1611-016	O-RING

NOTES:

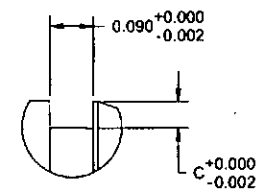
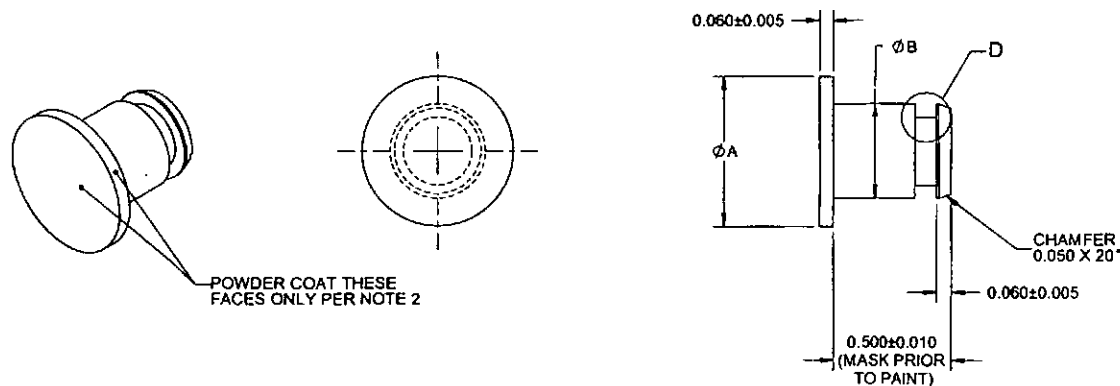
1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

105612 MWS
13-08-08

RELEASED
2011-05-30
JAN

D	INCORPORATED DED D3492-C-1, SHT 2 DIM C FOR -1 WAS 0.055, (SEE CAR11-048)	AJS	11.05.24
C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047, UPDATE DIM A FOR -045	PH	08.05.11
A	NEW ISSUE	PH	08.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	J.F.	DRAWING NO.	REV. ID
MFG. APPR.	J.F.	D3492	SHEET 1 OF 2
APPROVED	J.F.	TITLE	SCALE
DE APPR.	J.F.	PLUG	2:1
DATE	11.05.24	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE OR COMMUNICATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

105612



DETAIL D

D3492-XX PLUG

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.050	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500
D3492-9	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.850	0.664	0.045	M6061T6R0.875
D3492-13	0.750	0.510	0.045	M6061T6R0.750

NOTES:

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

RELEASED
2011-05-30
JWW

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	K	DRAWING NO.	REV. D
MFG. APPR.	JES	D3492	SHEET 2 OF 2
APPROVED	JW	TITLE	SCALE
DE APPR.		PLUG	4:1
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